

Date: Thursday, 5/10/2007 2:08:20 PM
 User: Kim Johnston

Process Sheet

SP11P

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FLOAT STEP
 Job Number : 32253
 Estimate Number : 10851
 P.O. Number : *N/A* Part Number : D206628023
 This Issue : 5/10/2007 S.O. No. : *N/A* Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : *N/A*
 Previous Run : 26752 Material : *N/A* Due Date : 5/30/2007 Qty: *1/4* Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:D As Per Ecn766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-023 CHG 002

2.0 32253A FLOAT STEP ASSEMBLY LH (206/407)



Comment: Sub-Component Sub-Assembly

FLOAT STEP ASSEMBLY LH (206/407)

D2842-041 B *32 253A*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug *1329339*

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm *1322284**7/6/21 Sg*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32253

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3

Arm

B27786

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total : 5.0639 f(s)

Pick :

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

B32020 ✓

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASS,Y

B30998 ✓

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M104214 ✓

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

M103691 ✓

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M19600 ✓

7/6/21 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32253

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

2
M100447 X M102952 X

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

4
M101061 X

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

220
M103962 M104214

15.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M103691 X

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M103715 X

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number


Description

Batch

3 NAS1515H3 Washer

M100993 X 7/12/07 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 07/06/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32253

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Logbook 1

10/10/07

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-023

Location: *F*

PPP Rev: *1*

10/10/07

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/10/07

Job Completion



U 10/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

106-1028.017

Dart Aerospace Ltd.

Date
User

Thursday, 5/10/2007 2:08:37 PM
Kim Johnston

Process Sheet










Step 28/06
split

0706-21

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY LH (206/407)
Job Number	: 32253A -2	Part Number	: D2842041
Estimate Number	: 11664	Drawing Number	: D2842 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/10/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 5/30/2007
Previous Run	: 31241A	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	: <u>07.05.10</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

070

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B31984</u>
Check Material for any Dents or Defects			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1			
1-Cut D2842-1 using D2622 extrusion as per Dwg D2842			
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842			
3-Deburr and bevel ends for welding			
3.0	D2734	206 Step Endplate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)			
206 Step Endplate			
Pick:	Qty	Part Number	Description Batch
	2	D2734	End Cap <u>B30883</u>
4.0	D34593	plate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch

07.06.19 4

07.06.19 4

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3459-3 Lug

331238

Pl 07-06-19

4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3459-1 Lug

330909

Pl 07-06-19

4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT as per Dwg D2842

Pl 07-06-20

4

A/R

AL Rod

Batch:

m102756

m104305

Pl 07-06-20

2-Grind end cap weld flush

FF 07-06-20

PE 07-06-20

2
2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Pl 07-06-20

Comment: INSPECT WORK TO CURRENT STEP

(4)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 07-06-20

(4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

G.M

07-06-20

(1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Pl 07-06-21

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(1)

Thursday, 5/10/2007 2:08:38 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

2-Grind end cap weld flush.

PE. 07-06-21

PE. 07-06-21

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/21 (LH) (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-21 (LH) (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M104144

M-L / BR.

(LH)

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

07/06/21

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M100712

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19522

FL 07/06/21 (1)

Thursday, 5/10/2007 2:08:38 PM
Kim Johnston

Process Sheet

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Customer: CU-DAR001 Dart Helicopters Services

Part Number: D2842041

Job Number: 32253A

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

m104603

washer

18.0

AN960C10L



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

m102473

HAND FINISHING RESOURCE #1

19.0

HAND FINISHING1



Comment: LARGE FABRICATION RESOURCE 1
1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

m104733

m104733

07/06/21

①

20.0

QC3/5



INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

PACKAGING RESOURCE #1

21.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PM

32353

07/06/21

①

22.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/21

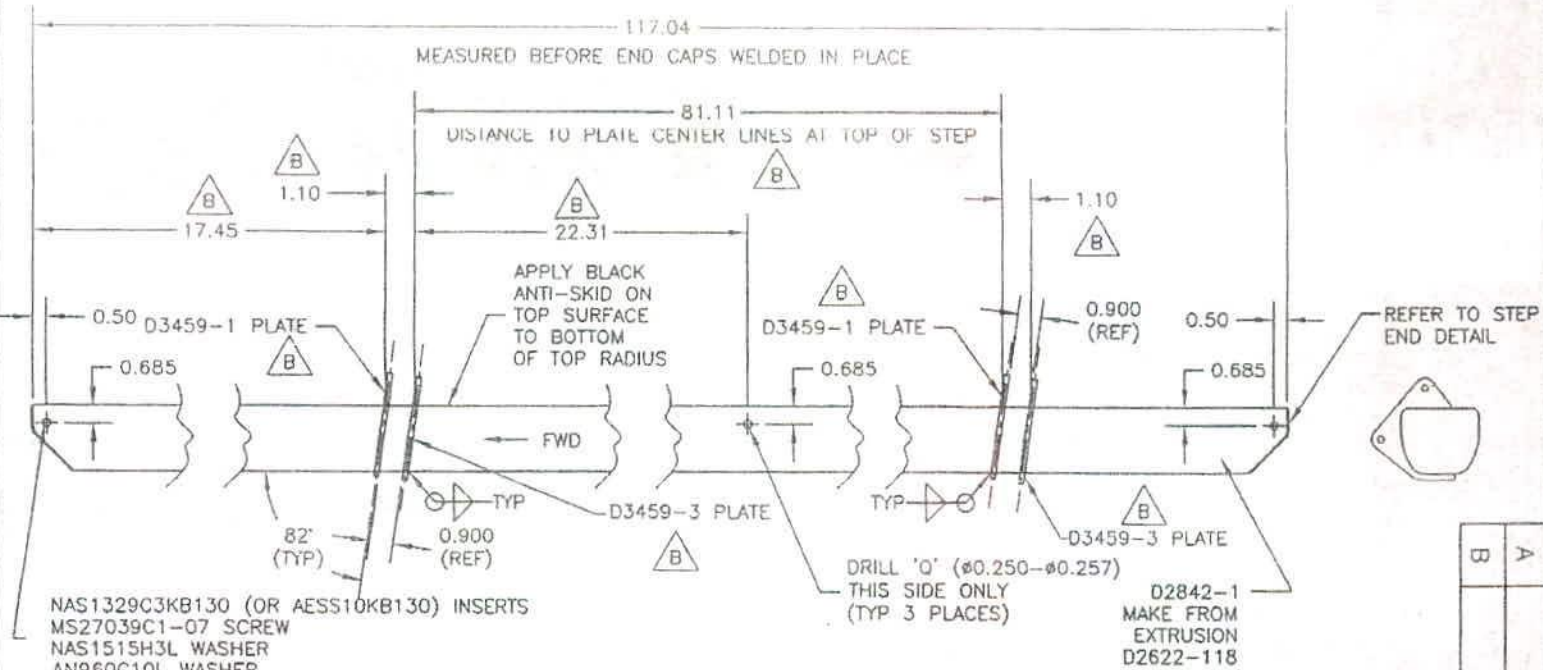
W 07-06-21

Job Completion





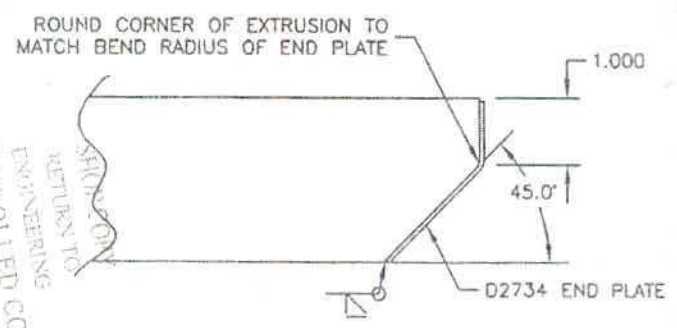
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY
A	98.10.13	NEW ISSUE
B	05.09.23	RE-DESIGN, ADD D3459-1/-3
		SCALE NTS
		SHEET 1 OF 1
		REV. B



D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SPECIFIC
WITHOUT NOTICE
WORK ORDER
NO. 92253A

RELEASED
05.11.14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-21	9.0	Split R 1 on this w/o : Qty 3 on original	J	07-06-21	1	J 07-06-21	J 07-06-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries